

Date: Tuesday, 8/28/2007 3:23:09 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE	
Job Number	: 34316				
Estimate Number	: 12737				
P.O. Number	: N/A		Part Number	: D353513	
This Issue	: 8/28/2007	S.O. No. : N/A	Drawing Number	: D3535 UNDER REVIEW <i>Rev B 07/08/31</i>	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A	
Previous Run	: 32268		Material	: N/A	
Written By	: <i>JL</i>		Due Date	: 9/14/2007	
Checked & Approved By	: <i>JL 07-08-28</i>		Qty:	20	Um: Each
Comment	: Est Rev A New Issue 07-02-15 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	M304S20GA	304/316 .040 Sheet			
		Comment: Qty.: 0.8930 sf(s)/Unit Total : 17.8605 sf(s) 304/316 .040 Sheet (M304S20GA)			
		Batch: <i>M105130</i>		<i>SAD</i>	<i>07/08/31</i>
2.0	WATER JET	FLOW WATER JET			
		Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: <i>B</i> Prog Rev: <i>B</i>			
		2-Deburr if necessary	<i>HB 07-09-12</i>	<i>SAD 07/08/31</i>	<i>20</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<i>SAD</i>	<i>07/08/31</i>
4.0	QC8	SECOND CHECK			
		Comment: SECOND CHECK		<i>Ep 07/09/12</i>	<i>X20</i>
5.0	BRAKE NC	NC BRAKE			
		Comment: NC BRAKE 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158Identify as D3535-13		<i>SB 07/09/25</i>	<i>20</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/09/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 3:23:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 34316

Part Number: D353513

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Fx 07/09/25 (20) cont'd

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Fx 07/09/26 (20)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

21 07-09-27 (20)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: FP-15

Fx 07/09/27 (20)

(20)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

22 07/09/28

Job Completion



u 07/09/28

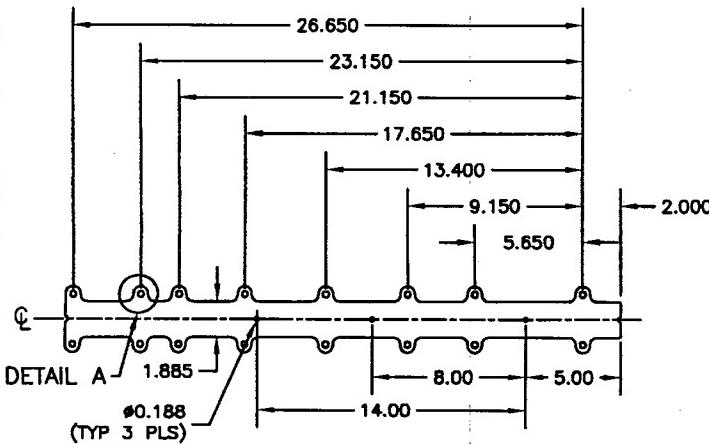
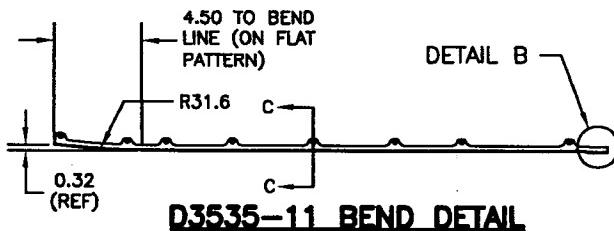
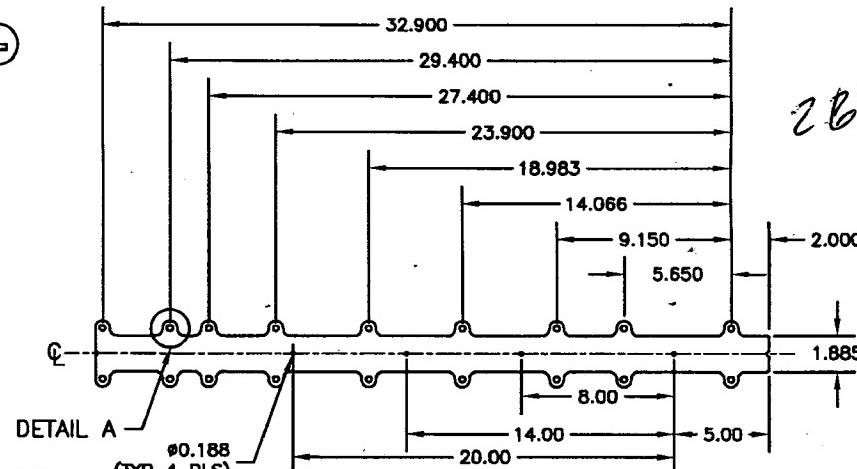
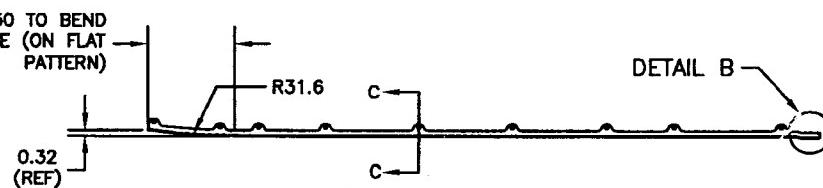
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
  - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
  - 3) PART IS SYMMETRICAL ABOUT  $\frac{Q}{2}$
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
  - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
  - 8) SEE PAGE 7 FOR DETAILS AND SECTION

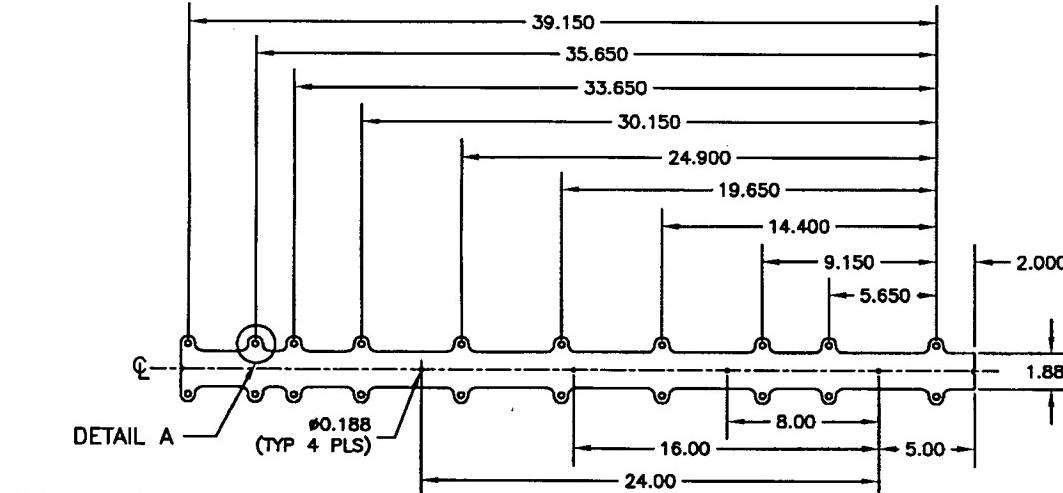
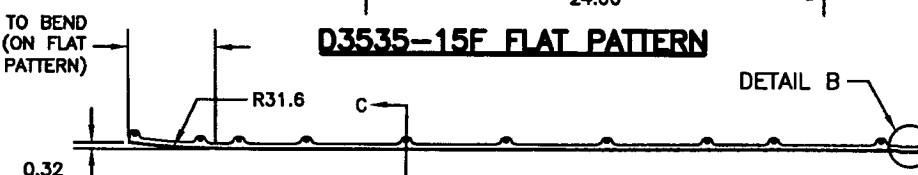
*286*

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
C.B	MH	DRAWING NO. D3535	SHEET 1 OF 7
CHECKED	APPROVED	DATE 07.04.17	SCALE 1:10
A	MH	06.10.25	NEW ISSUE
B	MH	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

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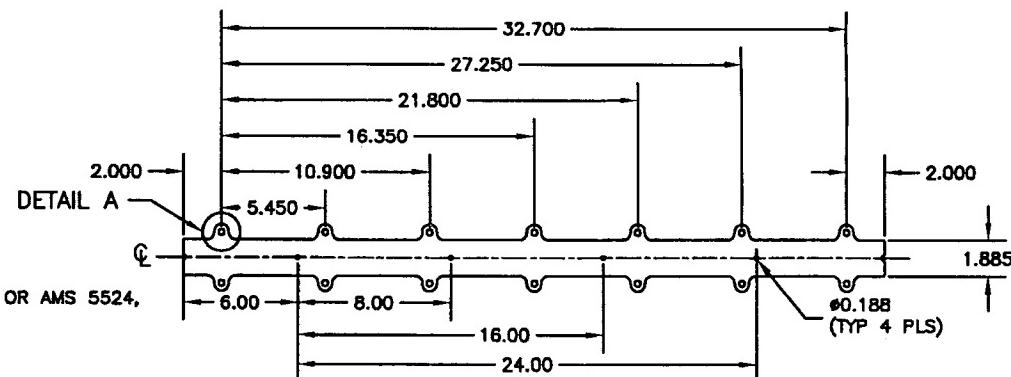
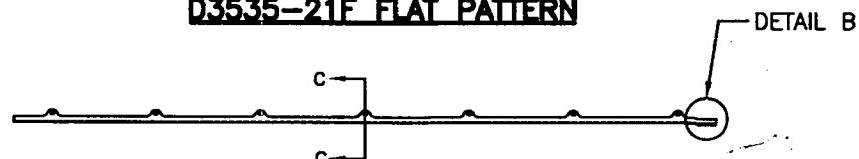
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**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL**

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**NOTES**

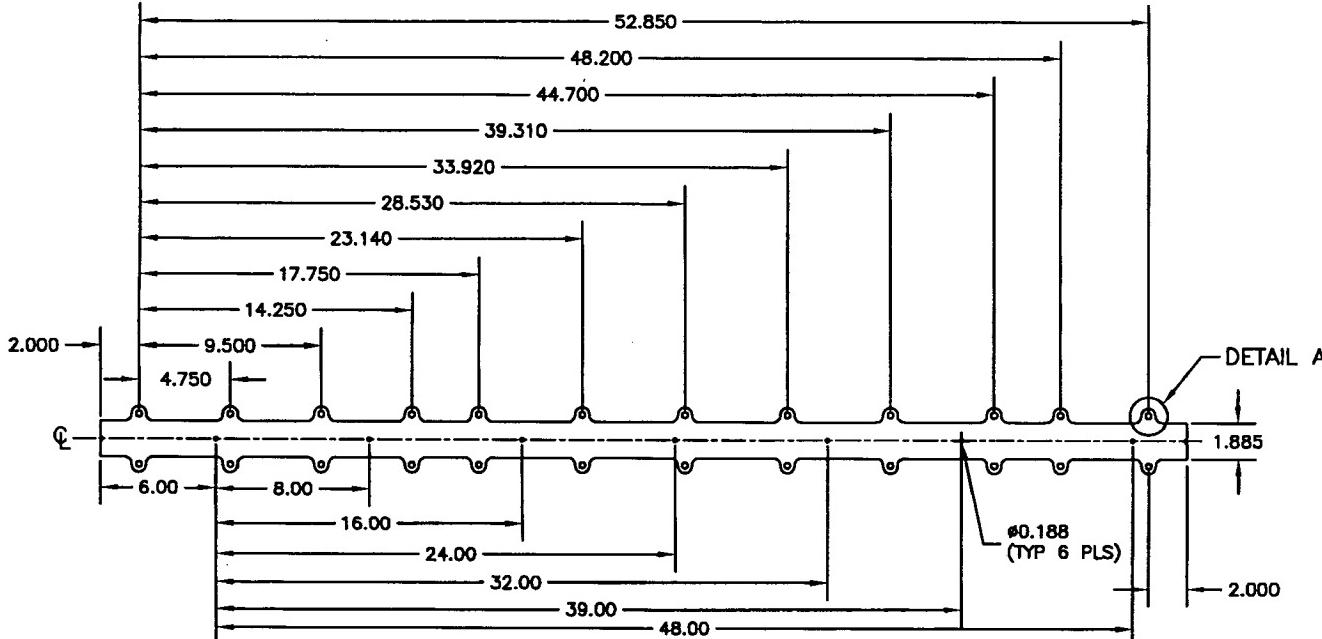
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

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DATE <b>07.04.17</b>		TITLE <b>WEARSHOE</b>

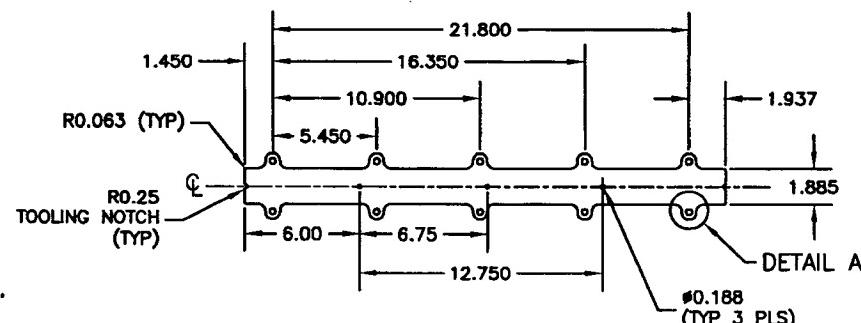
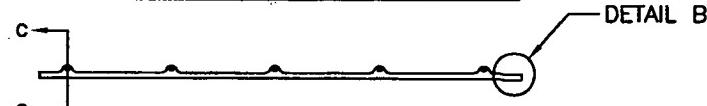
REV. B  
SHEET 3 OF 7  
SCALE 1:10

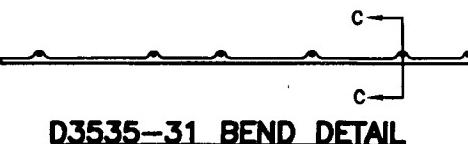
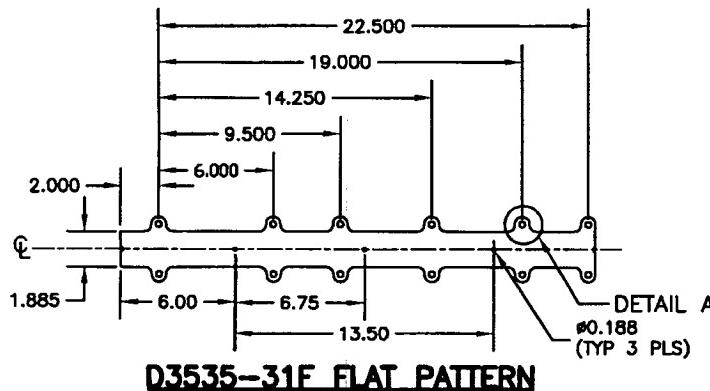
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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
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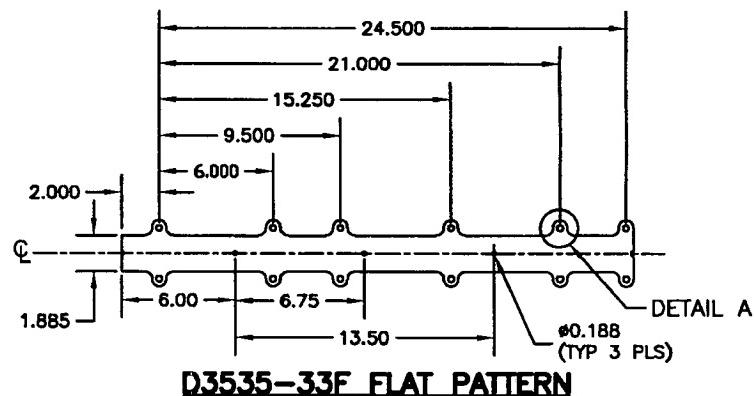
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20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
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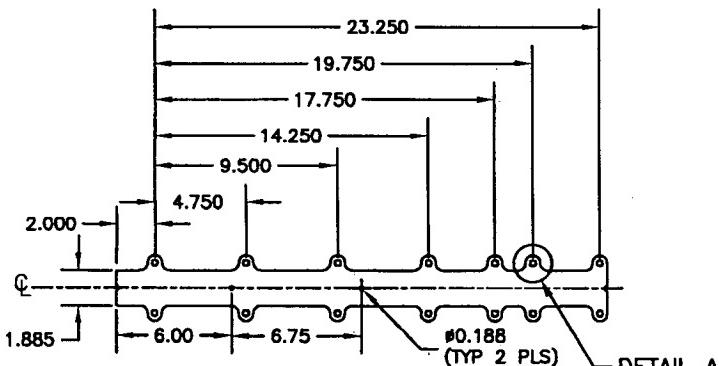
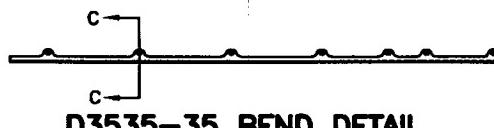
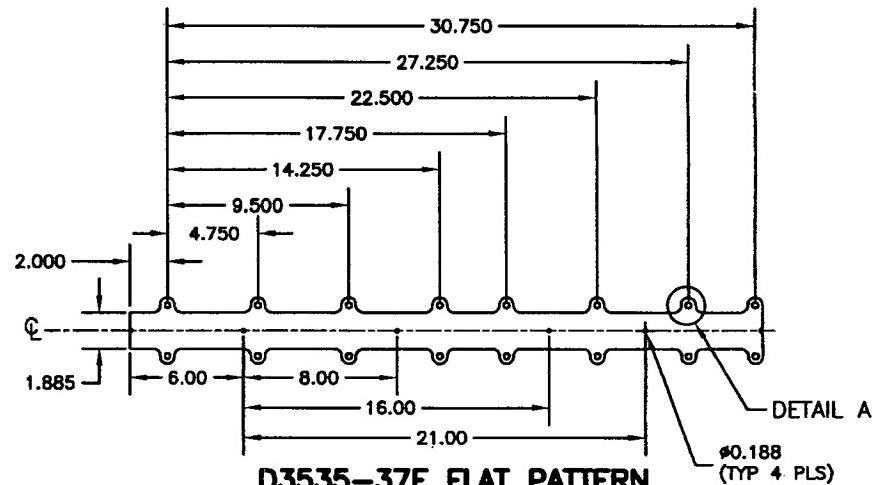


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		D3535
DATE		SHEET 4 OF 7
07.04.17		SCALE
		1:10
	TITLE	WEARSHOE

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**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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07.04.17		SCALE 1:10

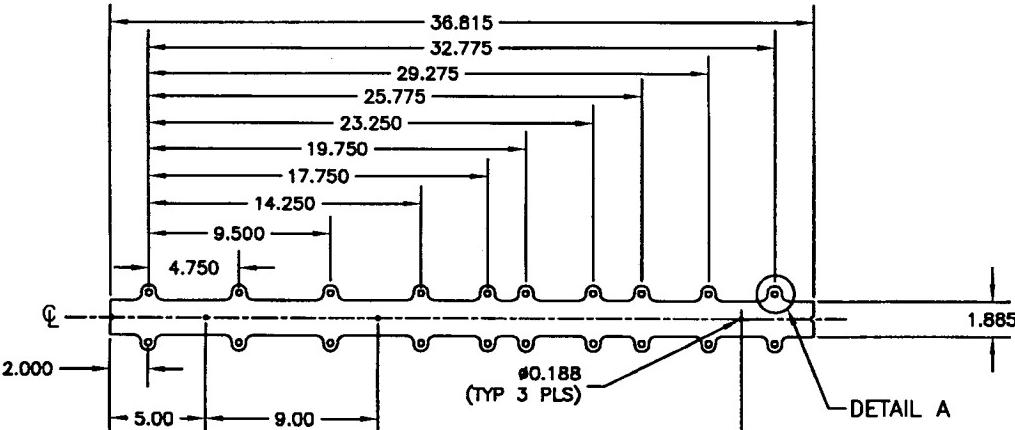
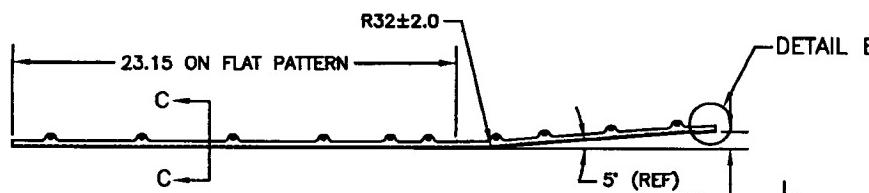
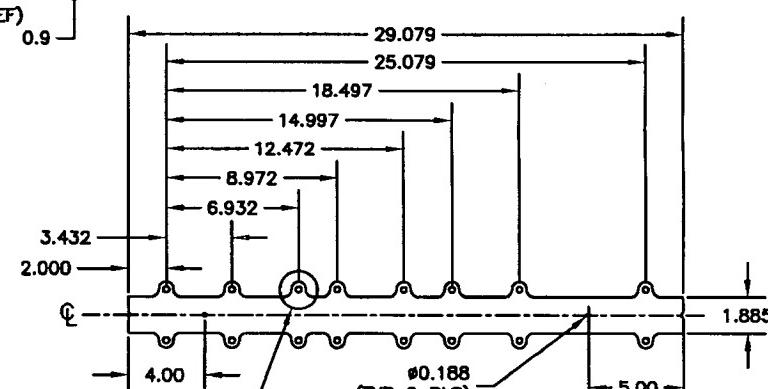
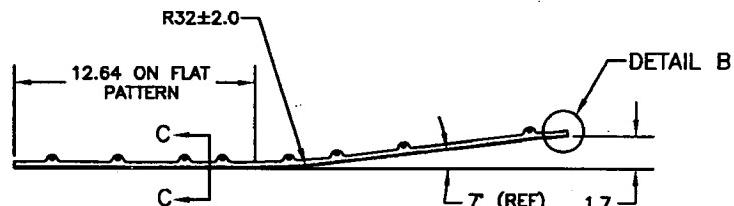
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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
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- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
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DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 6 OF 7 SCALE 1:10

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

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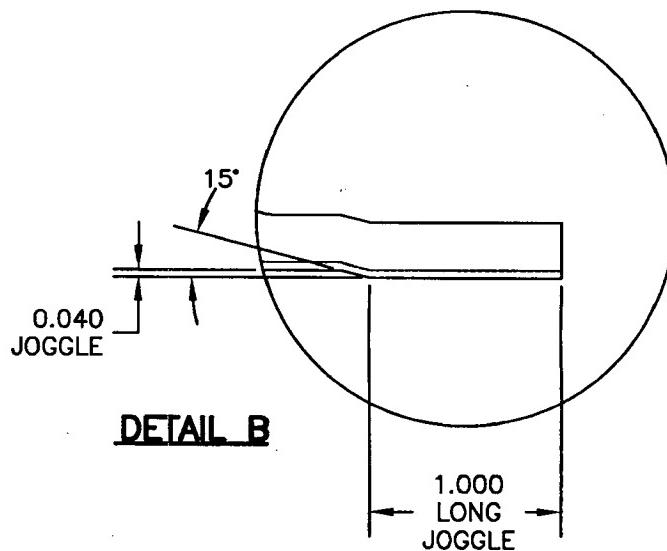
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
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PAINT MARKER
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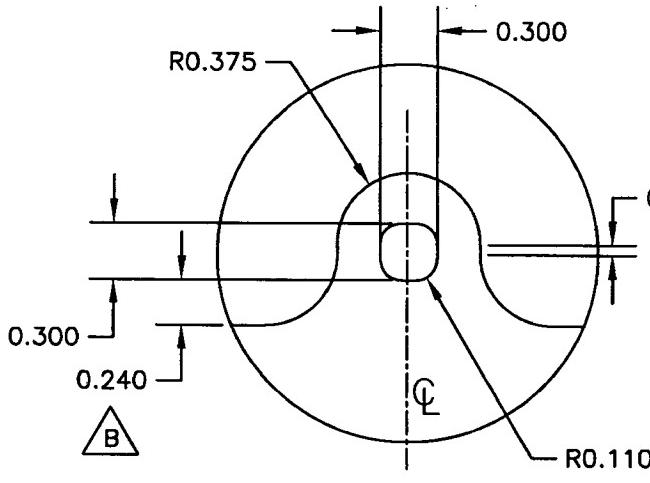
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 7 OF 7 SCALE 1:1

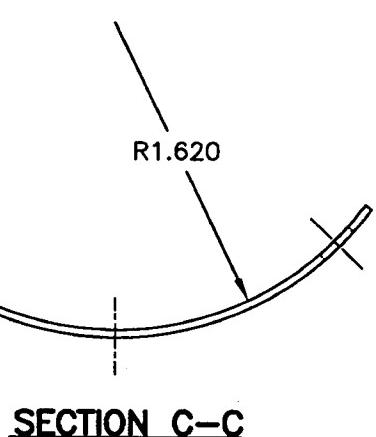
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DETAIL B



DETAIL A



SECTION C-C

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DART AEROSPACE LTD	Work Order:	34316
Description: GEAR SHOE	Part Number:	D353513
Inspection Dwg: D3535 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## **x First Article      Prototype**

Measured by:	SAS	Audited by:	Er	Prototype Approval:	W/A
Date:	13/08/13	Date:	07/09/14	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	